



PATENT ABSTRACTS OF JAPAN

(11) Publication number: **11033601 A**(43) Date of publication of application: **09.02.99**

(51) Int. Cl.

B21B 1/00(21) Application number: **09191481**(22) Date of filing: **16.07.97**(71) Applicant: **ISHIKAWAJIMA HARIMA HEAVY
IND CO LTD**(72) Inventor: **NARISHIMA SHIGEKI
HIGUCHI KINICHI
MORI KAZUMI**(54) **ROLLING EQUIPMENT**

stages of the rolling mill can be reduced.

(57) Abstract:

COPYRIGHT: (C)1999,JPO

PROBLEM TO BE SOLVED: To increase the kinds of steels for which a slab with a satisfactory quality is used, whose product quality is improved and which can be produced by heating a continuously cast slab by roller hearth furnace and working beam furnace, keeping the heat of the slab, adjusting a transfer speed, rolling it by a finishing mill, and winding it.

SOLUTION: By a first roller hearth furnace RH1 provided at the outlet of each continuous casting machine, the slab is transferred, is heated, and the heat of the slab is kept. The slab is supplied to the working beam furnace WBF through a roller table. Hereupon, the slab is heated further to a high temperature, for instance, 1200 to 1260°C. By a second roller hearth furnace RH2, while keeping the temperature of the slab, the slab is sent out at a speed adjusted to the bringing-in speed of the finishing mill. By the finishing mills F1 to F6, the slab is rolled to a sheet metal according to a specification, for instance, 1.5 to 1.0 mm, is sent to a down-coiler D/C, and is wound on a coil. Satisfactory finish rolling can be performed, and the number of the

